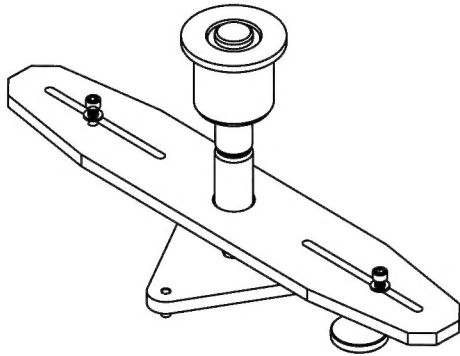
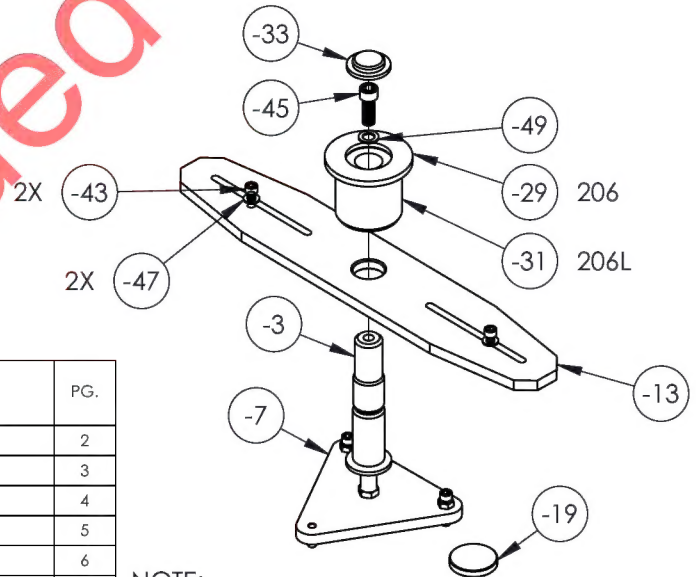


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDRAWN IN SOLIDWORKS PER UPDATED DWGS	1/18/2012	JAG	
2		CH'D -33 & -41 BOM B/O INFO. CH'D -11 ANGLE CALL OUT FROM 2X 60°. -29 ADDED DETAIL A & ENGRAVE ".29", DELETED R.05 & Ø1.537 FEATURES, CH'D DIAMETER FROM Ø1.435-1.437 TO Ø1.449-1.454. -31 ADDED DETAIL B & ENGRAVE ".31", DELETED R.05 & Ø1.537 FEATURES, CH'D DIAMETER FROM Ø1.435-1.437 TO Ø1.449-1.454 PER S.E.	3/16/2012	RJC	SE
3		-5 CH'D MATERIAL WAS 440C IS 303. -9 CH'D MATERIAL WAS 440C IS 303. CH'D STOCK SIZE WAS Ø1/2 X 4-7/8 IS Ø5/8 X 4-7/8. -11 CH'D MATERIAL WAS 440C IS 303. -13 CH'D MATERIAL WAS 2024 IS 6061. -21 CH'D MATERIAL WAS 440C IS 303. CH'D STOCK SIZE WAS Ø7/8 X 1/2 IS Ø3/4 X 1/2. -29 & -31 CH'D MATERIAL WAS 440C IS 303. CH'D STOCK SIZE WAS Ø2-3/4 X 2-5/16 IS Ø3 X 2-5/16.	6/25/2013	BIM	EB
4		-5 REMOVED HEAT TREAT REQUIREMENT, ADDED .13 X 45° DIM. -29 & -31 CH'D DIM. FROM .030 TO .03	11/26/2013	JAG	GE
4A		CH'D TITLE BLOCK TOLERANCE WAS .XXX ±.005 IS ±.010. WAS .XX ±.01 IS ±.03 PER BELL DWG. -9 CH'D MATERIAL WAS Ø5/8 303 IS Ø1/2 303 G&P. DELETED HEAT TREAT WAS RC 58 MIN.	3/26/2014	RJC	GE
5	15-0067	-9 CH'D MATERIAL WAS 303 G&P IS 440C. ADDED HEAT TREAT RC 54-60. -11 DELETED HEAT TREAT 9-25 HRC. -13 ADDED ENGRAVE T/N, S/N, MADE IN USA NOTE. -21 CH'D HEAT TREAT WAS FOR MILITARY HEAT TREAT RC 40-44, IS RC 54-60. -29 & -31 DELETED HEAT TREAT 35-40 HRC.	4/15/2015	RJC	JAG



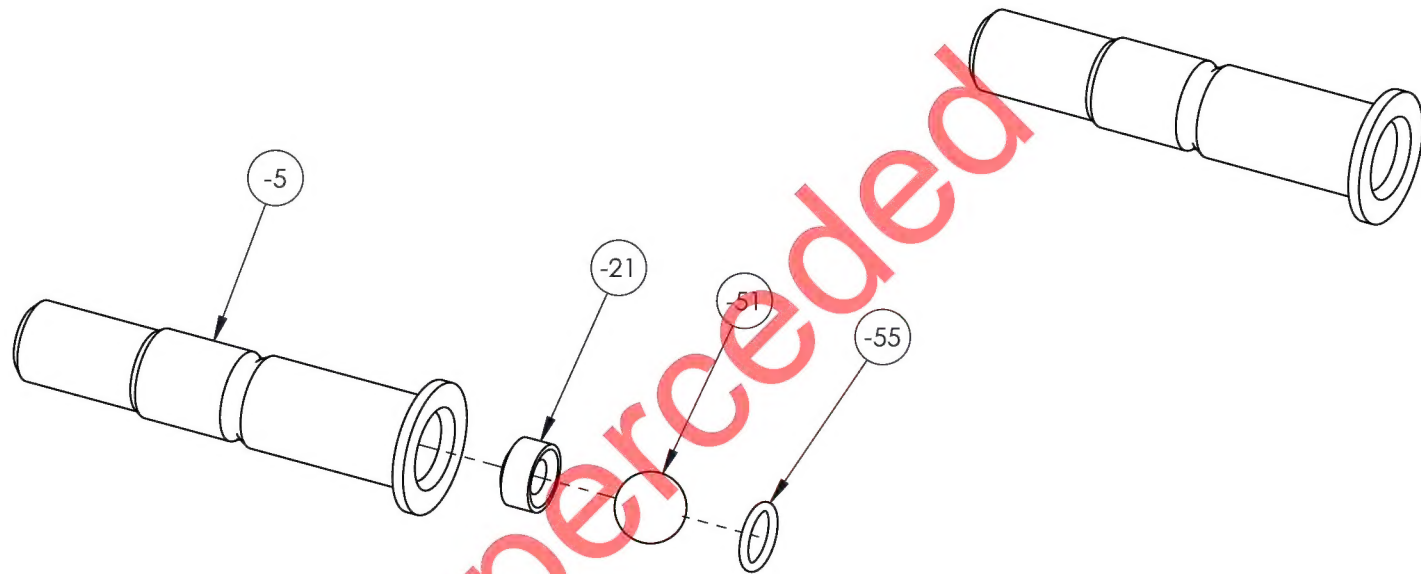
NOTE:
FOR 206 USE -29 IN ASSEMBLY
FOR 206L USE -31 IN ASSEMBLY

ASSY QTY	ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-3	1	MANDREL ASSY			2
	1		-5		MANDREL	303		3
X			-7	1	STAND ASSY			4
1			-9		STAND	440C		5
1			-11		PLATE	303		6
			-13	1	BASE	6061		7
			-19	1	PLATE	17-4 PH		8
1			-21		PLUG	440C		9
			-29	1	PLUG (USE ON 206)	303		10
			-31	1	PLUG (USE ON 206L)	303		11
		B/O	-33	1	BULL'S EYE LEVEL	BRASS	GEIER & BLUHN #2-14000 (MSC #05555933)	1
2		B/O	-37		HEX NUT	316	1/4-28 UNF (MCMaster-CARR #90257A033)	4
1		B/O	-39		HEX NUT	316	3/8-24 UNF (MCMaster-CARR #94805A217)	4
1		B/O	-41		DOWEL PIN	316	Ø1/4 X 3/4 (MCMaster-CARR #97395A485)	4
2		B/O	-43	2	SOCKET HEAD CAP SCREW	316	1/4-28 UNF (MCMaster-CARR #92185A564)	4
		B/O	-45	1	SOCKET HEAD CAP SCREW	316	3/8-24 UNF (MCMaster-CARR #92185A673)	1
		B/O	-47	2	FLAT WASHER	300 S.S	I.D. 1/4 (MCMaster-CARR #98017A660)	1
		B/O	-49	1	WASHER	300 S.S.	I.D. 3/8 (MCMaster-CARR #98017A200)	1
	1	B/O	-51		BALL	E52100 STEEL	Ø3/4 GRADE 25 (MCMaster-CARR #9528K29)	2
	1	B/O	-55		O-RING	VITON	Ø3/32 X I.D. 9/16 X O.D. 3/4 (MCMaster-CARR #2857T128)	2
ASSY -7	ASSY -3							

DART AEROSPACE	
TITLE BALANCE SET - MAIN & TAIL ROTOR	
DWG NO. RB T101576	REV 5
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: CLOUGH
.XXX ± .010	APPROVED D Weil
.XX ± .03	HEAT TREAT
.X ± .1	FINISH
FRACTIONS ± 1/8	SPEC
ANGLES ± 5°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:5	DATE 1/9/2012
SHEET 1 OF 11	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

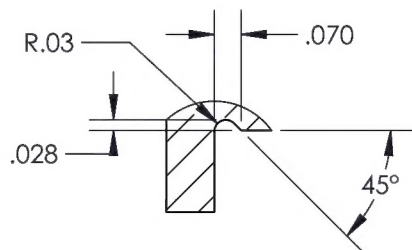


(-3)
MANDREL ASSY.

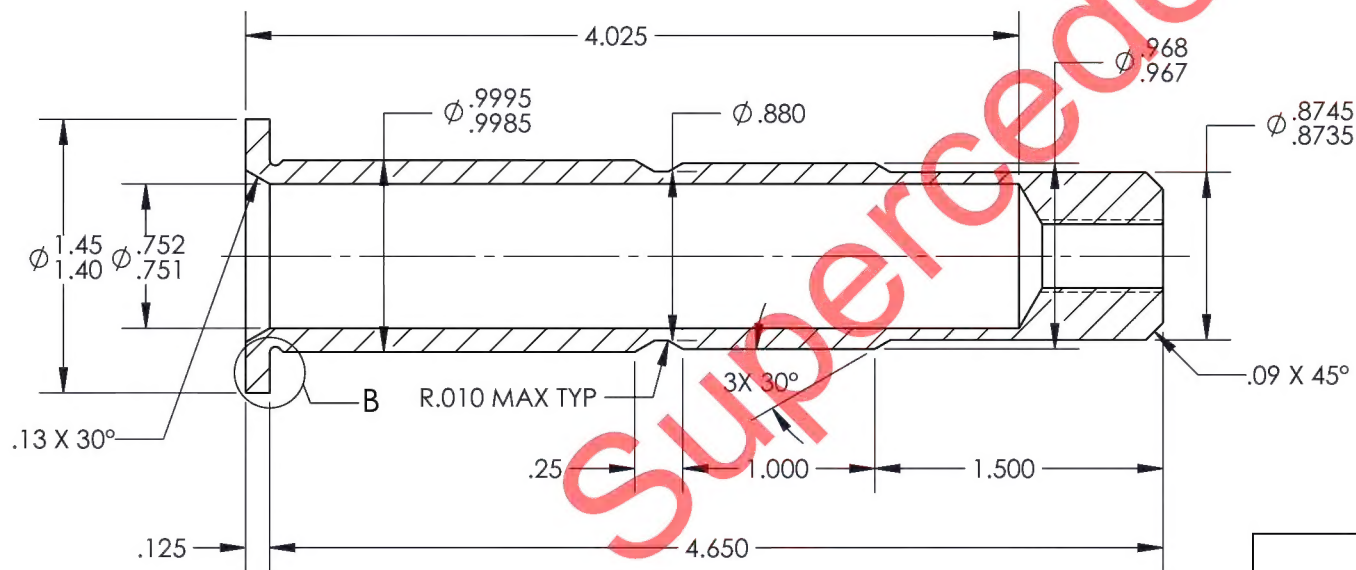
DART AEROSPACE	
TITLE BALANCE SET - MAIN & TAIL ROTOR	
DWG NO. RB T101576-3	REV 5
MAT'L	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010	HEAT
.XX ± .03	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	BELL 206 & 206L
SCALE 1:2	DATE 1/9/2012
	SHEET 2 OF 11

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		-5 CH'D MATERIAL WAS 440C IS 303.	6/25/2013	BIM	EB
4		-5 REMOVED HEAT TREAT REQUIREMENT, ADDED .13 X 45° DIM.	11/26/2013	JAG	GE



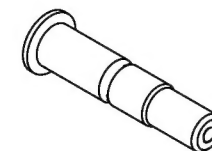
DETAIL B
SCALE 2 : 1



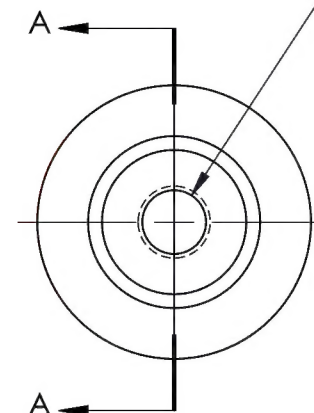
SECTION A-A

(-5)

MANDREL



3/8-24 UNF - 3B THRU ALL

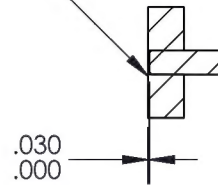


TITLE		
BALANCE SET - MAIN & TAIL ROTOR		
DWG NO.		REV
RB T101576-5		5
MAT'L 303		DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>
.XXX ± .010		HEAT
.XX ± .03		TREAT
.X ± .1		FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL
		BELL 206 & 206L
SCALE	1:1	DATE
		1/9/2012
		SHEET 3 OF 11

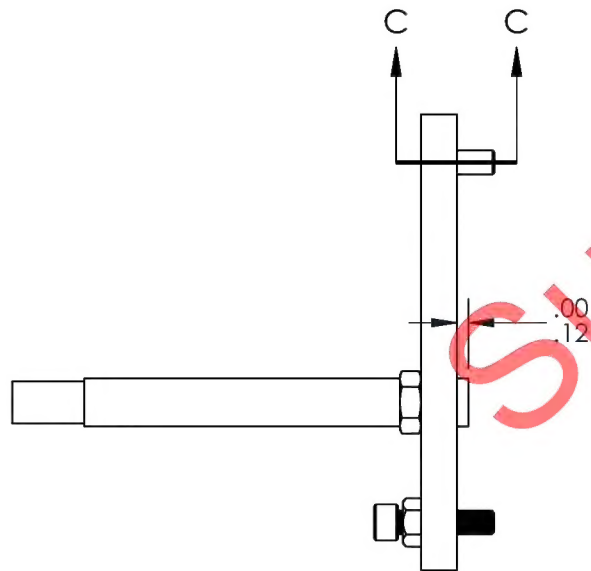
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

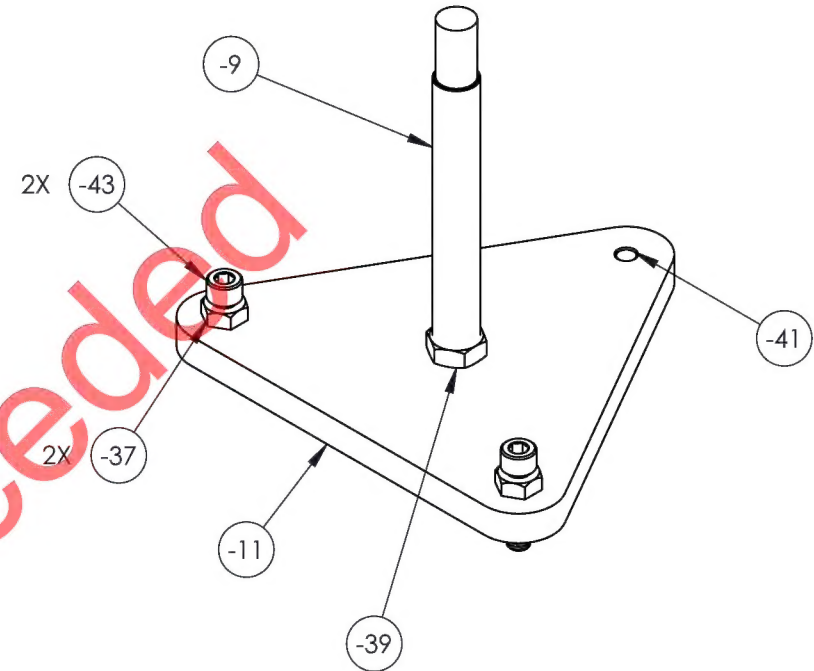
POINT STAKE PIN 3 PLCS THIS SIDE



SECTION C-C



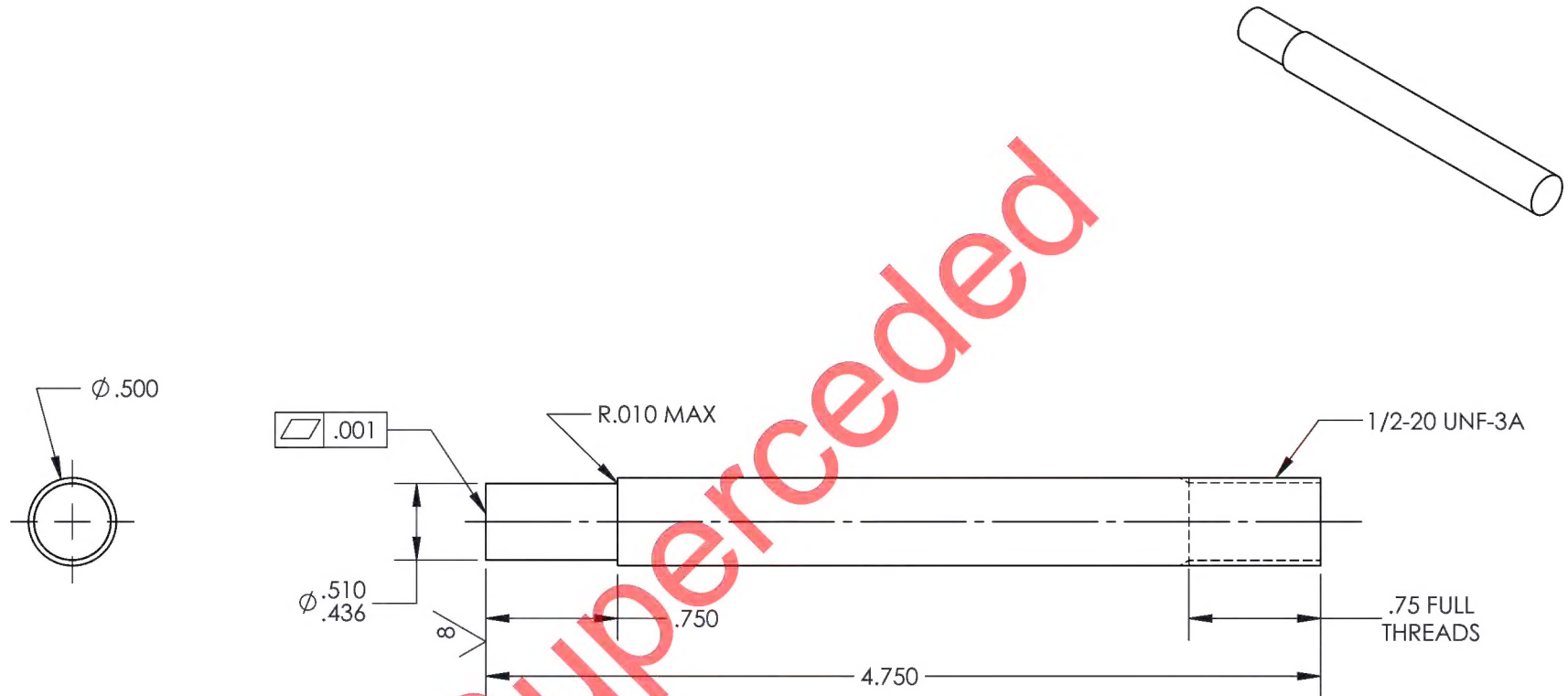
(-7)
STAND ASSY



DART AEROSPACE	
TITLE BALANCE SET - MAIN & TAIL ROTOR	
DWG NO. RB T101576-7	REV 5
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 5° .X ± .1	DRAWN BY: CLOUGH APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 206 & 206L
SCALE 1:2	DATE 1/9/2012
SHEET 4 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		-9 CH'D MATERIAL WAS 440C IS 303. CH'D STOCK SIZE WAS Ø1/2 X 4-7/8 IS Ø5/8 X 7/8.	6/25/13	BIM	EB
4A		-9 CH'D MATERIAL WAS Ø5/8 303 IS Ø1/2 303 G&P, DELETED HEAT TREAT WAS RC 58 MIN.	3/26/14	RJC	GE
5	15-0067	-9 CH'D MATERIAL WAS 303 G&P IS 440C, ADDED HEAT TREAT RC 54-60.	4/15/2015	RJC	JAG



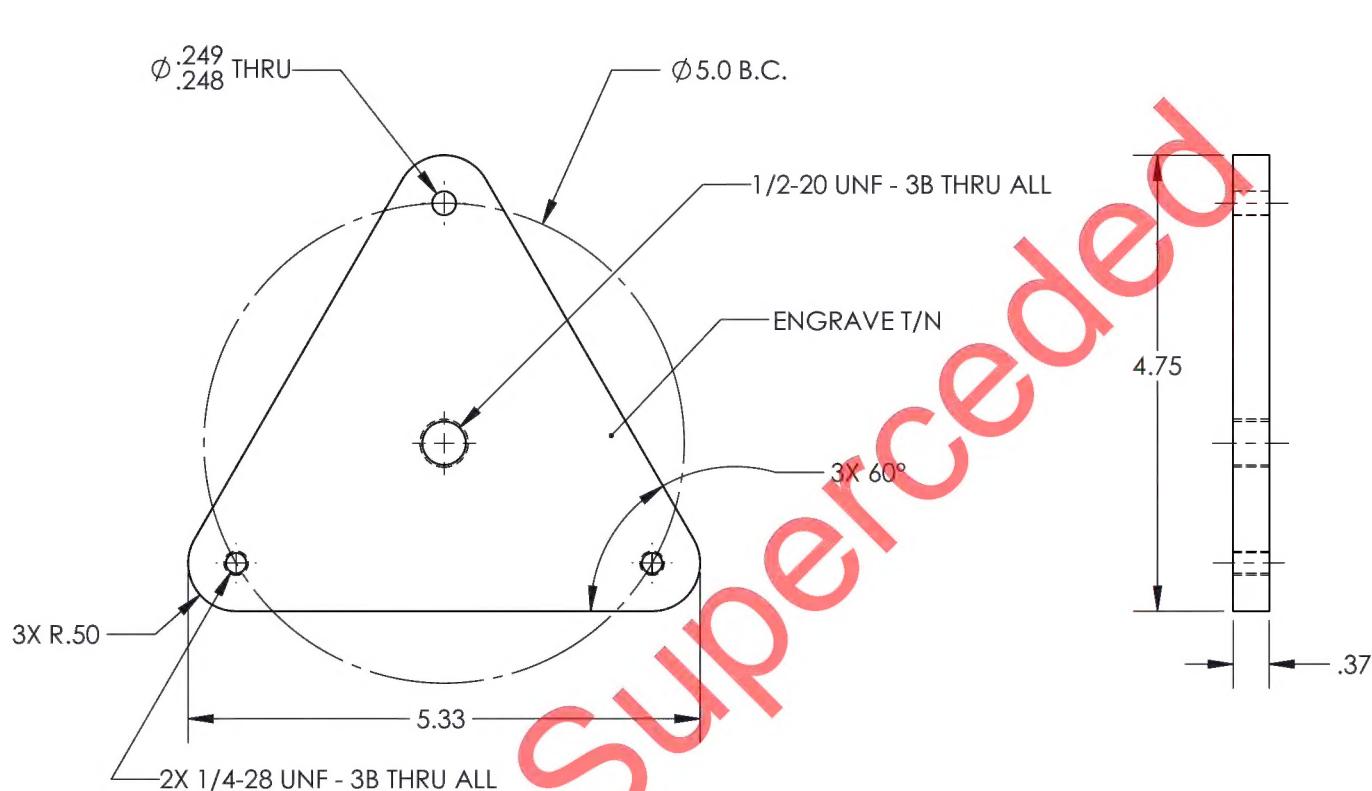
(-9)

STAND

DART AEROSPACE	
TITLE BALANCE SET - MAIN & TAIL ROTOR	
DWG NO. RB T101576-9	REV 5
MAT'L 440C	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT RC 54-60
.XX ± .03 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 206 & 206L
SCALE 1:1	DATE 1/9/2012
SHEET 5 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-11 ANGLE CH'D ANGLE WAS 2X 60° IS 3X 60°.	3/16/2012	RJC	SE
3		-11 CH'D MATERIAL WAS 440C IS 303.	6/25/2013	BIM	EB
5	15-0067	-11 DELETED HEAT TREAT 9-25 HRC.	4/15/2015	RJC	JAG



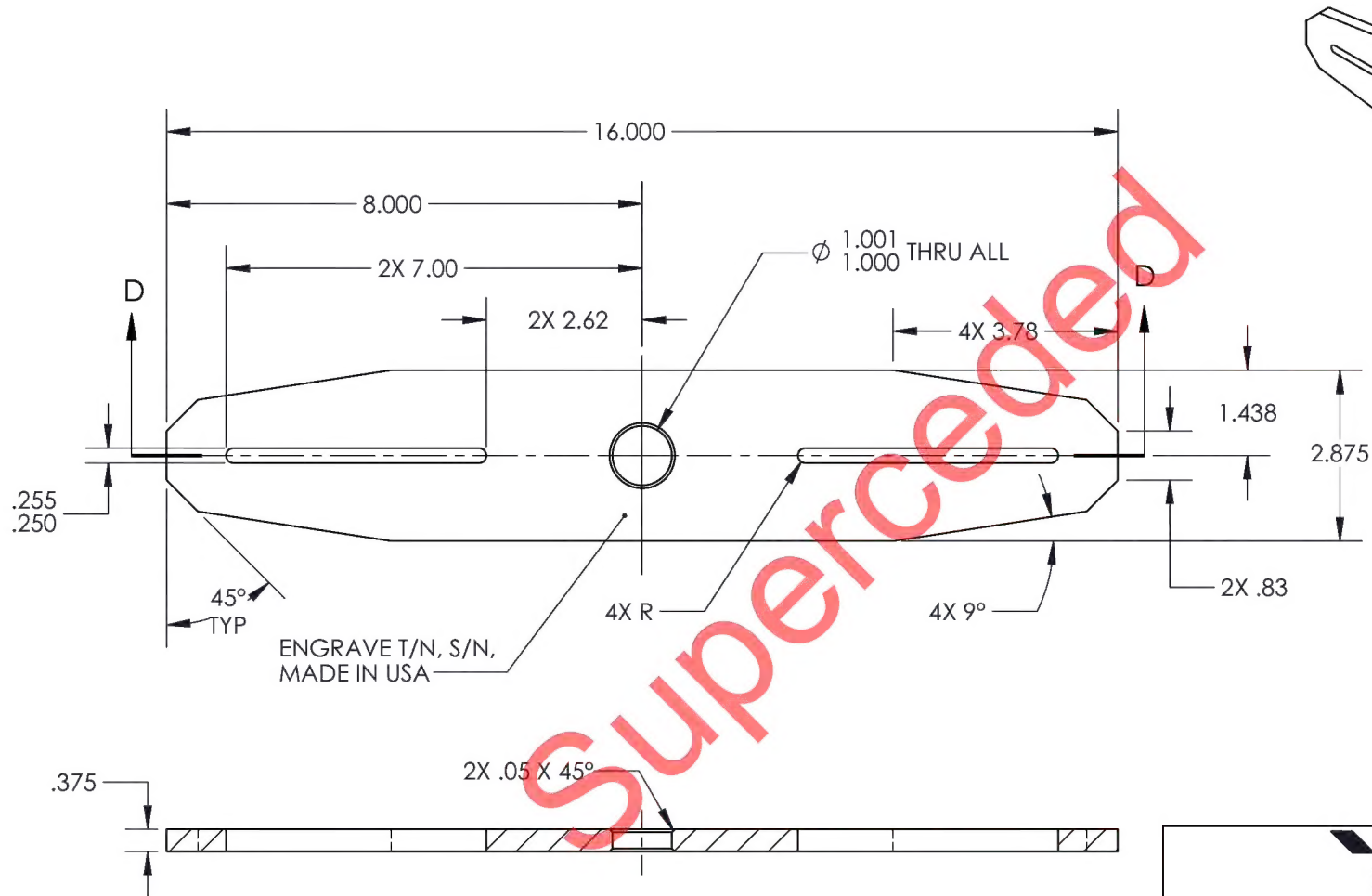
(-11)

PLATE

DART AEROSPACE	
TITLE BALANCE SET - MAIN & TAIL ROTOR	
DWG NO. RB T 101576-11	REV 5
MAT'L 303	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX \pm .010 FRACTIONS \pm 1/8	HEAT TREAT
.XX \pm .03 ANGLES \pm 5°	FINISH
.X \pm .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 206 & 206L
SCALE 1:2	DATE 1/9/2012
SHEET 6 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		-13 CH'D MATERIAL WAS 2024 IS 6061.	6/25/2013	BIM	EB
5	15-0067	-13 ADDED ENGRAVE T/N, S/N, MADE IN USA NOTE.	4/15/2015	RJC	JAG



SECTION D-D

(-13)

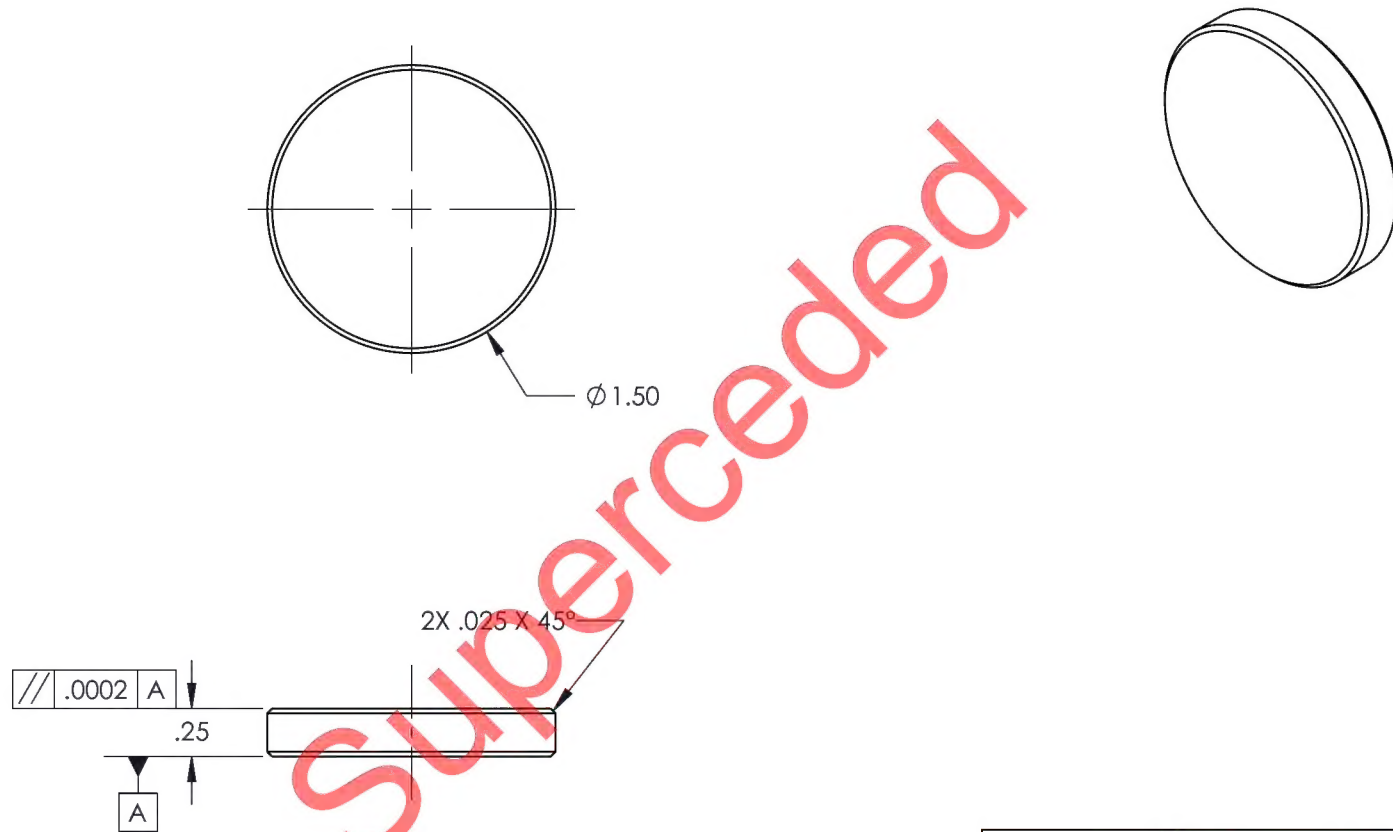
BASE



TITLE BALANCE SET - MAIN & TAIL ROTOR		
DWG NO. RB T101576-13	REV 5	
MAT'L 6061	DRAWN BY: CLOUGH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>	
.XXX ± .010	HEAT TREAT	
.XX ± .03	FINISH CLEAR ANODIZE	
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS I	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 206 & 206L	
SCALE 1:3	DATE 1/9/2012	SHEET 7 OF 11

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

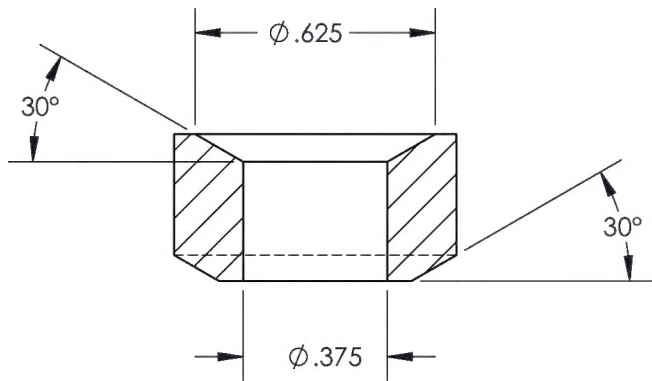


(-19)
PLATE

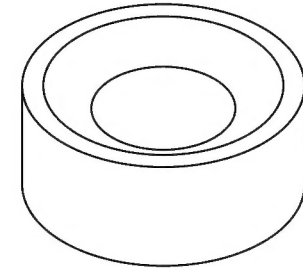
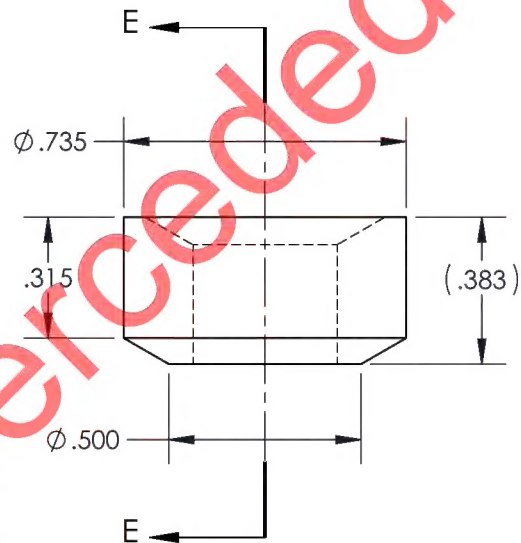
DART AEROSPACE	
TITLE BALANCE SET - MAIN & TAIL ROTOR	
DWG NO. RBT101576-19	REV 5
MAT'L 17-4 PH	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT 37-45 HRC
.XX ± .03 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 206 & 206L
SCALE 1:1	DATE 1/10/2012
SHEET 8 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		-21 CH'D MATERIAL WAS 440C IS 303. CH'D STOCK SIZE WAS Ø7/8 X 1/2 IS Ø3/4 X 1/2.	6/25/2013	BIM	SE
5	15-0067	-21 CH'D HEAT TREAT WAS FOR MILITARY HEAT TREAT RC 40-44, IS RC 54-60.	4/15/2015	RJC	JAG



SECTION E-E



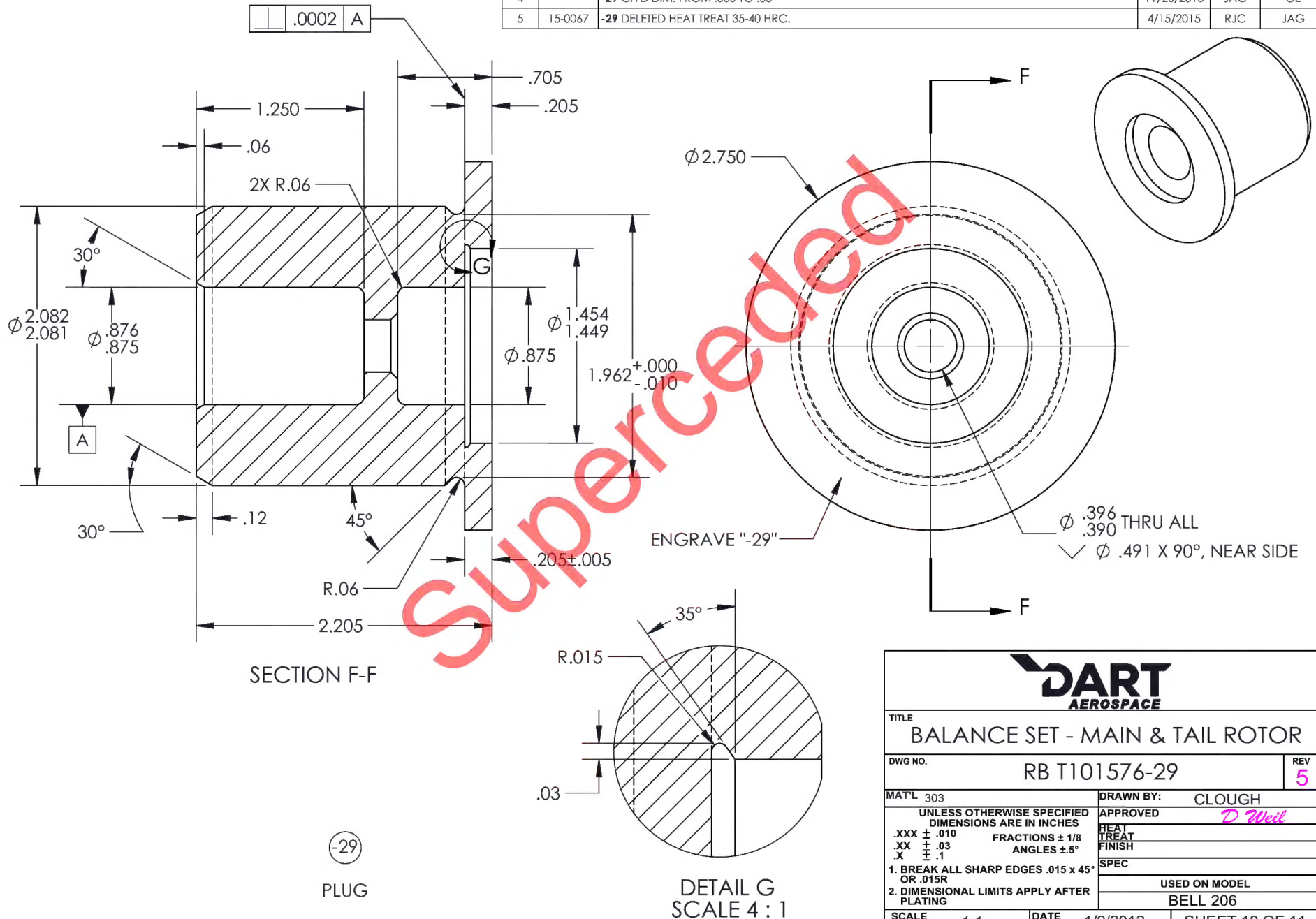
(-21)

PLUG

DART AEROSPACE	
TITLE BALANCE SET - MAIN & TAIL ROTOR	
DWG NO. RBT101576-21	REV 5
MAT'L 440C	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i> HEAT TREAT RC 54-60 FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 206 & 206L
SCALE 2:1	DATE 1/10/2012
SHEET 9 OF 11	

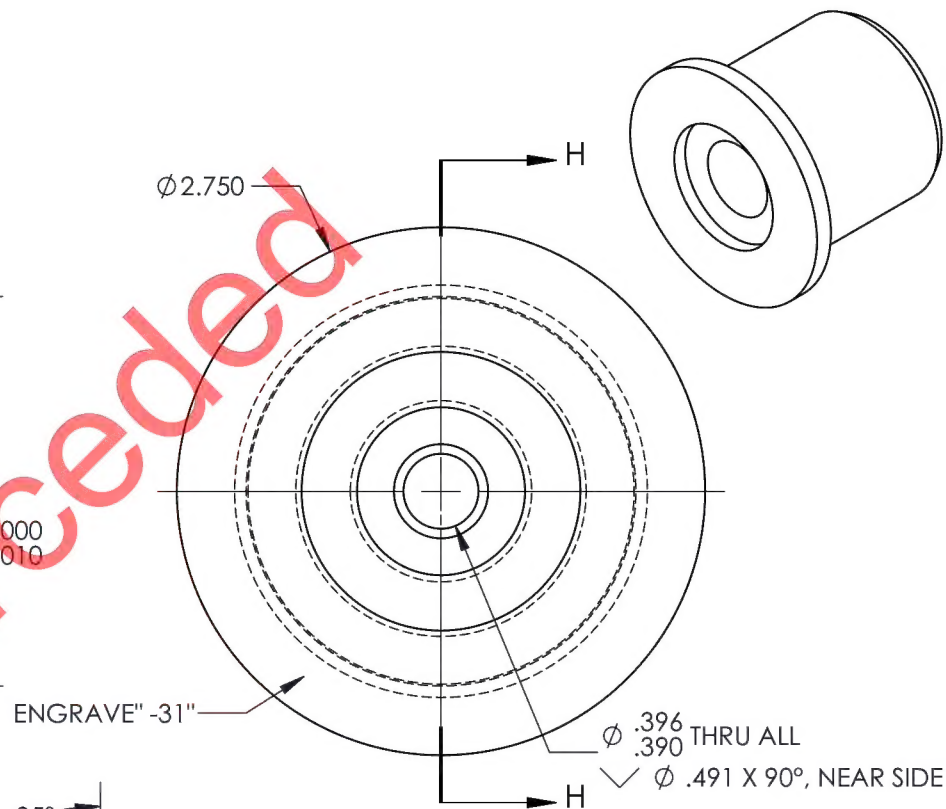
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-29 ADDED DETAIL A & ENGRAVE "-29", DELETED R.05 & Ø1.537 FEATURES, CH'D DIAMETER FROM Ø1.435-1.437 TO Ø1.449-1.454 PER S.E.	3/16/2012	RJC	SE
3		-29 CH'D MATERIAL WAS 440C IS 303, CH'D STOCK SIZE WAS Ø2-3/4 X 2-5/16 IS Ø3 X 2-5/16.	6/25/2013	BIM	EB
4		-29 CH'D DIM. FROM .030 TO .03	11/26/2013	JAG	GE
5	15-0067	-29 DELETED HEAT TREAT 35-40 HRC.	4/15/2015	RJC	JAG



DART AEROSPACE	
TITLE BALANCE SET - MAIN & TAIL ROTOR	
DWG NO. RB T101576-29	REV 5
MAT'L 303	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010	HEAT TREAT
.XX ± .03	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 206
SCALE 1:1	DATE 1/9/2012
SHEET 10 OF 11	

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-31 ADDED DETAIL B & ENGRAVE "-31". DELETED R.05 & Ø1.537 FEATURES, CH'D DIAMETER FROM Ø1.435-1.437 TO Ø1.449-1.454 PER S.E.	3/16/2012	RJC	SE
3		-31 CH'D MATERIAL WAS 440C IS 303. CH'D STOCK SIZE WAS Ø2-3/4 X 2-5/16 IS Ø3 X 2-5/16.	6/25/2013	BIM	EB
4		-31 CH'D DIM. FROM .030 TO .03	11/26/2013	JAG	GE
5	15-0067	-31 DELETED HEAT TREAT 35-40 HRC.	4/15/2015	RJC	JAG



PLUG



TITLE	BALANCE SET - MAIN & TAIL ROTOR
-------	---------------------------------

DWG NO.	RB T101576-31
---------	---------------

REV
5

MAT'L	303
-------	-----

DRAWN BY:	CLOUGH
-----------	--------

UNLESS OTHERWISE SPECIFIED

D	APPROVED
---	----------

DIMENSIONS ARE IN INCHES
XXX + .010 FRACTIONS: 1/8

HEAT TREAT	35-40 HRC
------------	-----------

.XXX	± .010	FRACTIONS ± 1/8
.XX	± .03	ANGLES ± .5°
.X	± .05	
0	± .07	

TREAT
FINISH

1. BREAK ALL SHARP EDGES .015 x 15

5.0	SPEC
-----	------

1. BREAK ALL SHARP EDGES .015 x 45
OR .015R

5	USED ON MODEL
---	---------------

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

R	USED ON MODEL
	BELL 206L

SCALE	1:1
-------	-----

DATE	1/9/2012
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SHEET 11 OF 11